

# ABSTRACT

5 A blow mold assembly for an I.S. machine for  
blowing a parison of glass and cooling the blown parison  
into a formed bottle which can be removed from the blow  
mold. A blow head is lowered onto a blow mold and final  
air is applied. A predetermined time after the blow head  
engages the top surface of the blow mold the blow head is  
10 lifted a selected vertical distance above the top surface  
of the blow mold to an exhaust position allowing cooling  
air to escape from the blow mold. The selected vertical  
distance is selected so that at least a minimum pressure  
will continue within the formed bottle. The blow head is  
15 maintain at the exhaust position for a predetermined time  
and then retracted. The selected vertical distance and  
the predetermined time can be set as desired.

TOP SECRET - 1005000